Work Orde June-23-14 12:3	er ID 121310 ~ 2 35:29 PM		*121	310*						Page 1
Item ID: Revision ID:	D3602-1		Accept	*N90004	4010	<u>)</u> 0*	Setup	Start	*N	S1*
Item Name:	Angle		Æ					Stop	*N:	S2*
Start Date:	6/23/14 Start Qty: 50.00	*5	0* 4	Cust Item ID:						
Required Date:	7/21/14 Req'd Qty: 50.00) * 5	0*	Customer:						
Reference:	٨	. ,	、							
Approvals:	Process Plan:	Date:	Tooling:	Date:			Run	Start Stop	~1/1	R1*
	QC:	Date:	SPC (Y/N):	Date:				Stop	*N	R2*
Sequence ID/ Work Center II	Operation D Description		Set Up/ Run Hours	Tool ID To	ool# Pla Coo	_	t Re Qt		Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr									
D3602	Rev B									
105			0.00				- n			
105 Purchasing	Memo		0.00				Li	4106	23	<u> 30</u>
Purchasing		STAINLESS WITH PL	ASTIC WRAP***							
		per Dwg D3602								
	Prog Rev		10:24728							
	2-Deburr	if necessary	•					÷		
115	Receive & Inspect for	Damage & Mat'l Certs	0.00					7	,	
115 Packaging Packaging	Memo		0.00				17	14.	25 (50

June-23-14 12:35:29 PM

												_
Item ID: Revision ID:	D3602-1			Accept	*N900	040	100) *	Setup Star Sto	171	S1*	
Item Name: Start Date: Required Date: Reference:	Angle 6/23/14 7/21/14	Start Qty: 50.00 Req'd Qty: 50.00	*50* *50*		Cust Item I Customer:	D:				"IVI	S2*	
Approvals:	Process Pl	an:	Date:	Tooling:	Da	ate:		I	Run Sta	^I <i>V</i> I	R1*	
	QC:		Date:	SPC (Y/N):	Da	ate:			Sto	*N	R2*	
Sequence ID/ Work Center II	D	Operation Description		Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp	_
125		QC6- Inspect dimensions to	drawing	0.00								
195 QC Quality Control		Memo	·	0.00	inlosto 7		•			-		
130 *1 20*		Small Fab		0.00								
Small Fab Small Fab		Memo Form as per Dy	wg D3602	0.00								
140		QC5- Inspect part complete	ness to step on W/O	0.00								
1 4 N QC Quality Control		Memo	5/08/12	0.00								
•			\.									

N	ork	Order	ID	1213	10
7 7	OI D	Oluci	11/		Lυ

121310

Page 3

June-23-14 12:35:29 PM

Required Date: 7/21/14

Item	ID:	
Revis	sion	ID:

D3602-1

Accept

N900040100

Setup

Start

Stop

Item Name: Start Date:

Angle 6/23/14

Start Qty: 50.00

Req'd Qty: 50.00

50

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Start Run

Stop

Sequence ID/

Work Center ID

QC:

Operation Description Set Up/ **Run Hours** Tool ID

Tool # Plan Code Accept Qty

Reject Qty DAS Reject Insp. Number Stamp

150

150 Packaging

Memo

0.00

0.00

Packaging

wrap parts separately and properly to avoid scratches.

Date:

AUG 12 20014

160

QC21- Final Inspection - Work Order Release

Identify as per dwg & Stock Location: 57174

0.00

160

OC. **Quality Control**

Memo

0.00

Picklist Print

June-23-14 12:35:29 PM

Work Order ID: 121310 *121310*

Parent Item: D3602-1

Parent Item Name: Angle

D3602-1

Start Date: 6/23/14

Required Date: 7/21/14

Page 1

Start Qty: 50.00

Required Qty: 50.00

Comments:

IPP Rev:A New Issue 07-02-27 JLM

IPP Rev:B 08-12-11 as per ECN08-577 DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3602-1P		Purchased	No				Each	0.0000	•	50	<u> </u>		
*D3602-11	D *								**	5	10/1/2	25 (-	ر ت کي

Angle

36.25 REF R347 REF B 3.05 → Ac1-1 **D3602-1 ANGLE** SCALE 2X (MAKE FROM D3602-1F) B^{2.348} **D3602-1F FLAT PATTERN** R0.13 TYP В ADDED ROUNDED SHAPE: R347 REF AND 3.05; 2.348 WAS 2.328. REF: NCR#09-014 В MB 09.02.02 **NEW ISSUE** Α 07.02.20 MB REV. DESCRIPTION BY DATE NOTES: 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 20 GAUGE, 0.038 THICK, PER AMS 5513 OR AMS 5524, REF. DART SPEC. M304S20GA DESIGN DART AEROSPACE LTD DRAWN HAWKESBURY, ONTARIO, CANADA CHECKED DRAWING NO. REV. B 2) FINISHT: NUME
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFY WITH DART P/N "D3602-1" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.97 lbs D3602 MFG. APPR. SHEET 1 OF 1

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115 NOT TO BE USED FOR AMY PAPPOSE OR COPIED OR COMMAN-AERO TO ANY OTHER PERSON WITHOUT

WRITTON PERSONS FOR OWN ARRESTINGS.

APPROVED

DE APPR.

DATE

09.02.02

TITLE

ANGLE

SCALE

NTS

Linda Lacelle

From:

Nigel Forbes

Sent:

June-23-14 12:16 PM

To:

Linda Lacelle

Subject:

Re: rfq

Sold

Sent from my iPhone

On Jun 23, 2014, at 11:57 AM, "Linda Lacelle" < llacelle@dartaero.com > wrote:

These are the parts Sylvie has been struggling with...I say we just bite the bullet and order 50 of these...your thoughts?

From: Pedro Mendez [mailto:pedro.mendez@tnb.com]

Sent: June-23-14 11:19 AM

To: Linda Lacelle **Subject:** Re: rfq

Hi Linda parts will not marks but 304 -5513 not have #4 finish did you need that type of finish? if yes I can offer to pass at the

Time saver and get 180 grain

Regards

Pedro Mendez

Représentant technique Technical Sales Representative Thomas & Betts Manufacturing Inc. - GFI Division 180 Avenue Labrosse, Pointe-Claire Quebec, Canada H9R 1A1

(514) 630-4877- EXT 228

(514) 630-4849

Email: pedro.mendez@tnb.com

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The Confidentially Notice is available on this site.

http://groupwise.tnb.com/disclaimer/

On Mon, Jun 23, 2014 at 10:54 AM, Linda Lacelle <llacelle@dartaero.com> wrote:

Perfect, I will send a PO today. Can you ensure the parts will be shiny, no marks? material must be 4P finish.

Thx

Linda

From: Pedro Mendez [mailto:pedro.mendez@tnb.com]

Sent: June-23-14 10:46 AM

To: Linda Lacelle **Subject:** Re: rfq

Hi Linda

Rfq for D3602-1

10 pcs = 108.00\$ each

20 pcs = 62.00\$ each

50 pcs = 34.00\$ each

4 weeks delivery cad filr required

Regards

Pedro Mendez

Représentant technique Technical Sales Representative

Thomas & Betts Manufacturing Inc. - GFI Division

180 Avenue Labrosse, Pointe-Claire Quebec, Canada H9R 1A1

₾ (514) 630-4877- EXT 228

(514) 630-4849

Email: pedro.mendez@tnb.com

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Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K6A 1K7

Tel: 613 632 9577 Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO24728

Purchase Order Date 6/23/2014 PO Print Date 6/23/2014

Page Number 1 of 2

Order From:

GFI

180 AVENUE LABROSSE POINTE CLAIRE, QC H9R 1A1

CA

VC-GFI001

Ship To:

DART AEROSPACE LTD

1270 ABERDEEN

HAWKESBURY, ON K6A 1K7

CANADA



Contact Name

Vendor Phone

Ship To Contact

Ship To Phone

Ship Via:

Ship Acct:

514 630 4877

FedEx PI collect

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607 Net 30

Terms Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	D3602-1P	Angle	7/21/2014 Yes 7/21/2014		50.00 Each	\$34.00	\$1,700.00
	MACHINE AS PER DWG D3 B121310	602 REV. B					
						Line Total:	\$1,700.00
2	71401-45	PROCUREMENT QUALITY CLAUSES	7/21/2014		1.00	\$0.00	\$0.00

PROCUREMENT OUALITY CLAUSES A005 RIGHT OF ENTRY

No 7/21/2014

A008 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION SENT TO DART AEROSPACE) A012 CHEMICAL AND PHYSICAL TEST REPORTS A016 PERSONNEL QUALIFICATION A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)

A026 CERTIFICATION OF MATERIAL CONFORMANCE

A041 QUALITY MANAGEMENT SYSTEM A042 DART NOTIFICATION BY SUPPLIER

A043 RETENTION OF QUALITY DOCUMENT

Note:



180 AVENUE LABROSSE POINTE-CLAIRE, QC, CANADA H9R 1A1 TÉL.:(514) 630-4877 - FAX:(514) 630-4849



BON DE LIVRAISON /SHIPPING MEMO

DATEDELIV	RAISONISHI	PPINGDATE	N° DE BON DE LIVRAISON	PAGE
JR-DV	MO-MO	AN YR	SHIPPING MEMO AC	
24	07	14	0541476	1/1

3FI est une division de Thomas & Betts Limitée / GFI is a division of Thomas & Betts Limited

√ENDU À /SOLD TO

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 EXPÉDIÉ À ISHIP TO

DART AEROSPACE LTD 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

CO CO	DE DE CHENT STOMER CODE	Nº DE CONTRAT JOSHO	908 908	TRE'N' DIE COMMANDE BRURCHASE ORDER NO	EXPÉDIÉ PAR SHIP VIA
DART	GFI-0299	0287922		PO24728	
QLIANTITE JUANTITY		N°DEPIECE PARINE			ESCRIPTION .
50 1	D3602-1P	•	,	ANGLE	
,				ITEM 1 C OF C REQ'D FAI REQ'D	
		955 551	oty 50		
l l	MFG. JOB# <u>J0287</u> DUE DATE: <u>July</u> .			-	
		87 100 130 130			
			• •		
	**				

CERTIFICATE OF COMPLIANCE CERTIFICAT DE CONFORMITE



180 LABROSSE AVENUE POINTE CLAIRE, QC H9R 1A1

DRAWINGS AND PURCHASE ORDER REFERENCED ABOVE.

23 JULY 2014

DATE

<u>DART AEROSPACE LTD</u> 1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7

m Quantity purchase or	der part number i	REV NAME	DWG ISSUE
50 PCS PO24728	D3602-1P	B CUPPED WASH	HER B
MATERIAL	SUPPLIED BY	MA	T. REL. NO.
0 THK AMS 5513 304 ANN	TW METALS / NORTH AMER	RICAN	H/N # J5A8
PROCESS		PROCESSOR	release note
FIRST ARTICLE INSPECTIO	N REPORT ATTACHED	GFI	N/A
REF. GFI MANUFACTURING JOB N	(UMBER J0287922-001 (50 PCS)	GFI	N/A
	·		
	.]		
	1		
]
		·	

G.F.I. Q.C. REP.



1 Wright Avenue - Rear

LeRoy

NY 14482

Tel: 585-768-5600 FAX: 15857685601

CERTIFICATE OF COMPLIANCE

		Your C	Order Number:	0084131	
		Our delivery re	ceipt Number:	12099422	
	•		Date:	5/09/14	
					•
This is to ce	ertify that the material shipped against the	above order on t	he above delive	ry receipt, consisting of:	
	•	Quantity:	68.00	O LB	
•					
Line Number:	1	Grade:	304 ANNEALI	ED AMS5513 .040	
					
Part#:	TS040481204A		. -		
•					
leat Number:	J5A8 \				
-	- 0110 5			•	
Specification:					
Complies in all	respects with the item description.		:		
			,		
	•			And the second s	

BY: Janice Clark

Authorized Test Department Clerk

NAS NORTH AMERICAN STAINLESS

METALLURGICAL TEST REPORT

6870 Highway 42 East Ghent, KY 41045-9615 (502) 347-6000

Page: 1

Certificate: 868822 02 Mail To:

UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON, OH 45015 Ship To:

UNITED PERFORMANCE METALS 3475 SYMMES ROAD HAMILTON, OH 45015 Date: 9/10/2013

Steel: 302/304/304L

Finish: 28

Your Order:

Customer: 0018 001

01023126

NAS Order:

AN 0582364 01

Corrosion: ASTM A262/10;180Bend-OK

PRODUCT DESCRIPTION:

S/S COIL.C.R.ANNEALED & PICKLED; UNS 30400/30403/30200

ASTM A240/13a,A480/13,A666/10;ASME SA240/11a,SA480/11a,SA666/11a

CHEM ONLY ON FOLLOWING ASTM: A276/13,A479/13a,A484/13a,A312/13

CHEM ONLY ON FOLLOWING ASME: SA312/11,SA479/11

AMS 5511H/5513J/5516P XMRK;MIL-S-5059D AMD3(X CRN MEAS);MIL-4043B

NACE MR0175/ISO 15156-3:2003 A, MR0103/07;QQS766D-A X MAG PERM

MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs. EN 10204:2004 3.1; RoHS 1 & 2 Compliant Material is Free of Radioactive Contamination NAS Steel Making Process: EAF, AOD, & Cont. Casting Product Mfg.by a Quality Mgt.Sys. in Conf. w/ISO 9001 *Melted & Manufactured in the USA; Mat'l is DFARs Compliant

Product ID	Supplier ID	Thickness	Width	Weight		Length	Mark	Pieces	COMMODITY	CODE	
03J5A8 A	* 03J5A8	.0401	48.0000	25,740	COIL	3920.0	11	1			

CHEMICAL	ANA	LYSIS	CM(Cou	intry of Melt)	ES(Spain) U	S(United State	s) ZA(South	Africa) JP(Jap	oan)	Chemical	analysis per ASTM A751/08
HEAT Supplier#	CM	С %	CR %	CU %	mn %	MO %	N %	NI %	P %	s %	
J5A8 J5A8	us	.0171	18.0335	.4285	1.7885	.3570	.0827	8.0085	.0315	.0010	FF
		si %					,	<u> </u>			(6)
		.2430									The contract of the contract o

MECHANICAL PROPERTIES

Product Id	Supplier Id	1 d 0 i c r	UTS KSI	.2% YS KSI	ELONG %-2"	Hard RB	Tail Hard	180 Be	Grain No.	D Fer F.N.	
03J5A8 A	03J5A8	F T	95.23	44.99	54.73	83.00	85,00	OK	9.00	2.66	REVIEWED/APPROVED BY UPM QC
,								÷-			SPECS: AMS 5511 H, 5513 J 55/16/2
			•			a		-			ASTM-A-240-13
				•							BY: PI DATE 9-16-13 TOTAL PAGES [

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical Dept. Mgr.

ERIC HESS

9/10/2013

Form 1: Part Number	Acc	countability		Sheet 1 of 3
1. Part Number	_	2. Part Name	3. Serial Number	4. FAI Report Number
D3602-1P		ANGLE	NA .	D3602-1P REV B
5. Part Revision Level		6. Drawing Number	7. Drawing Revision Level	8. Additional Changes
REV. B		D3602	REV. B	N/A
Manufacturing Process Reference		10. Organization Name	11. Supplier Code	12. P.O. Number PO24728
J0287922-001		GFI	VC-GFI001	ITEM 1
13. Detail FAI	X	14. Full FAI	Baseline Part Number including r	evision level
Assembly FAI		Reason for Partial FAI:	J	
a) if above part number is a de b) if above part number is an a	etail p	part only, go to Field 19 nbly, go to the 'INDEX' section below.		
*		ub-assembly numbers requir	ed to make the assembly n	oted above.
15. Part Number		16. Part Name	17. Part Serial Number	18. FAI Report Number
			,	
				·
·				
•				
		·		<u>.</u>
•				·
1) Signature indicates that all ch	aracte	eristics are accounted for, meet drawin	g requirements, or are properly doc	umented for disposition.
2) Also indicate if the FAI is com	plete	per Section 5.4: X FAI complete	FAI not complete	
19. Signature	etan	- de Ad	<u> </u>	20. Date
21. Reviewed By DALTON HAROLD		\(\frac{\text{S}_{\omega}^{\text{S}_{\omega}}\te		22. Date 24 JULY 2014
23. Customer Approval		The state of the s	·	24. Date

Form 2: Product Accountability - Raw Material, Specifications, and Special Process(es), Functional Testing Sheet 2 of 3

1. Part Number S6144-35	2. Part Name ANGLE, SALVAGE	REWORK	3. Şerial Number N/A		4. FAI Report Number S6144-35 REV L
5. Material or Process Name	6. Specification Number	7. Code	8. Special Process Supplier code	9. Customer Approval Verification (Yes/No/NA)	10. Certificate of Conformance Number
MATERIAL	AMS 5513 304 ANN	.040 THK	TW METALS / NORTH AMERICAN	YES	J5A8
IDENTIFY INK STAMP	-		GFI	YES	N/A
		,			
			·		
	-	·			
		·			
			,		
		·	·		
			,		
	11 to 2 1 to	2 1 2			
11. Functional Test Procedure Number	12. Acceptance Report	Number, if applicable			
					· · · · · · · · · · · · · · · · · · ·
,			•		
10.0		GFI	· · · · · · · · · · · · · · · · · · ·		
13. Comments	·	8 (50 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5 5			
14. Prepared By DALTON HAROLD		W Iso		15. Date 24 JULY 2014	

AS9102 Revision A

Form 3: Characteristic Accountability, Verification and Compatibility Evaluation

1. Part Number		2. Part Name	3. Serial Number	4. FAI Report
D3602-1P		ANGLE		D3602-1P
2002	•		N/A	REV. B
•				

	Ch	aracteristic	Accountability	Inspection			
5. Char No.	6. Reference Location	7. Characteristic Designator	8. Requirement	9. Results	10. Designed Tooling	11. Non conformance no.	14. (Insert columns, etc, as required by Organization or customer)
1	SHEET 1 OF 1	NOTE 1	MATERIAL : AISI 304 /316 SST 20 GAUGE, 0.038 THK	.040 THK AMS 5513 304 ANN TW METALS / NORTH AMERICAN C/C # J5A8	POINT MIC, VISUAL	ACCEPT	
2	SHEET 1 OF 1	NOTE 2	FINISH: NONÉ	CONFORMS	VISUAL	ACCEPT	
3	SHEET 1 OF 1	NOTE 3	TOLERANCE: PER DART QSI 018	CONFORMS	VISUAL.	ACCEPŢ	
4	SHEET 1 OF 1	NOTE 4	UNITS: INCHES UNLESS	CONFORMS	VISUAL	ACCEPT	
5	SHEET 1 OF 1	NOTE 5	BREAK SHARP EDGES	CONFORMS	VISUAL	ACCEPT	,
6	SHEET 1 OF 1	NOTE 6	IDENTIFY WITH DART P/N: D3602-1	IDENTIFY INK STAMP, D3602-1	VISUAL	ACCEPT	
7	SHEET 1 OF 1	NOTE 7	WEIGHT: 0.97 LBS	CONFORMS	VISUAL	ACCEPT	
8	SHEET 1 OF 1	D3602-1F F/P	2.348	2.323	VERNIER	ACCEPT	·
9.	SHEET 1 OF 1	D3602-1F F/P	36.25	36.25	VERNIER	ACCEPT	
10	SHEET 1 OF 1	D3602-1F F/P	R .013 TYP	R 0.13 TYP	RADIUS / GA	ACCEPT	
11	SHEET 1 OF 1	D3602-1' ANGLE	3.05	3.05	VERNIER	ACCEPT	
12	SHEET 1 OF 1	D3602-1 ANGLE	R 347 REF	R 347	RADIUS / GA	ACCEPT	
13.	SHEET 1 OF 1	D3602-1 ANGLE	36.25 REF	36.25 REF	VERNIER	ACCEPT	
14	SHEET 1 OF 1	SECT A-A	70°	70°	PROTRACTOR	ACCEPT	
15	SHEET 1 OF 1	SECT A-A	R 0.13	R 0.13	RADIUS / GA	ACCEPT	
16	SHEET 1 OF 1	SECT A-A	1.19	1.18	VERNIER	ACCEPT	
17	SHEET 1 OF 1	SECT A-A	1.19	1.19	VERNIER	ACCEPT	

The signature indicates that all characteristics are accounted for; meet drawing requirements, or are properly documented for disposition.

12. Prepared By DALTON HAROLD

13. Date 24 JULY 2014

AS9102 Revision A